



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-214
Job Sheet 178757



Part No: D350-591-214

Job Qty: 4 ea

Part Name: Heli-Access-Step™ RH - High Gear, Short Step, Aerazur Float Compatible

JUN 25 2018



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/7/18

Job Tracking No:

Due Date: 7/4/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV H IPP Rev:B 05.10.14 Modified step 10 KJ/EC IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D 10.11.15 update qty on AN4-11A DD verf:EC IPP REV:E 14.12.17 ADD DSI9712-011 DD VERF:JLM IPP REV:F 16.03.16 IIN REV:H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	7/4/18	7/4/18	0.00	0.00	Start Up Stores/Pkg-2		JUN 25 2018
270	Packaging	4 pcs	7/4/18	7/4/18	0.00	0.00	Packaging1-3		JUL 04 2018
280	QC	4 pcs	7/4/18	7/4/18	0.00	0.00	QC4		JAB 28
290	Packaging	4 pcs	7/4/18	7/4/18	0.00	0.00	Packaging3-1		JAB 9-89
295	DC	4 pcs	7/4/18	7/4/18	0.00	0.00	DC		JAB 9-89
300	QC21-FG	4 Ea	7/4/18	7/4/18	0.00	0.00	QC21		JUL 05 2018

Part Op 290 - Identify and pack for shipping as per PPP D350-591-214 Location:FG039
Descriptions: 295 - Photocopy bluefile and type labels as per PPP D350-591-214 CHG005

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-35A	Bolt	8 Ea (2 ea)	90-Start up Operation	5067891
AN4-15A	Bolt	16 Ea (4 ea)	90-Start up Operation	5057424
AN5-36A	Bolt	8 Ea (2 ea)	90-Start up Operation	5068165
D2230-3	Mounting Lug	8 Ea (2 ea)	90-Start up Operation	5058081
D2618	Bushing	8 Ea (2 ea)	90-Start up Operation	5048859
D2732-030	Rubber Cushion (\$Per Foot)	4 Ea (1 ea)	90-Start up Operation	5073491
D3078-042	Step Assembly, Hi Short RH	4 Ea (1 ea)	90-Start up Operation	5080102
D3235-1	Mounting Lug	8 Ea (2 ea)	90-Start up Operation	5060874
D3338-1	Mounting Lug	4 Ea (1 ea)	90-Start up Operation	5080379
MS21042L3	Nut	8 Ea (2 ea)	90-Start up Operation	5078167
MS21042L4	Nut	24 Ea (6 ea)	90-Start up Operation	5067898
MS21042L5	Nut	8 Ea (2 ea)	90-Start up Operation	5058178
NAS1149D0363J	Washer	16 Ea (4 ea)	90-Start up Operation	5052109
NAS1149D0463J	Washer	48 Ea (12 ea)	90-Start up Operation	5067900
NAS1149D0563J	Washer	16 Ea (4 ea)	90-Start up Operation	5068162

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-35A	8	308	0
	AN4-15A	16	289	0

Work Order: _____
Part No. _____
NCR No. _____

DISPOSITION

Suspect: _____

AGAINST DEPARTMENT/PROCESS

Skid-tube _____
Finishing _____
Cross tube _____
Small Fab _____
Finishing _____
Rec/Store/Packaging _____
Supplier _____
Water Jet _____
Prod. Eng. Coord. _____
Engineering _____
Quality _____
Other _____

MRB (QS1042) Approval

Date: _____ Step #: _____

Description Work Order Deviation

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K0A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S083998
Part: D350-591-214
Job No: 178757
Serial No/Batch: S083998
Revision: _____
Inspector: _____
Exp Date: _____
Instructions: _____

Date: 06/25/18

Root Cause

Environment
Design
Doc/Data
Equip/Tooling
Handling/Pre
Material
Internal Transport
Tribal Knowledge
LOA
Substation
Past Expiry Date
Misidentified

No Re-verification
Operator
Offset/Setup
Supplier
Training
Use for Testing
Poor Information
Rushing
Product Improvement
Process Improvement
Manufacturing Process
Past Due

Pressure/Forced
Bending
Centre Not Concentric
Cracks
Crimp/Kink/Ripple/Wave
Cuffs
Crushing
Heat Treat
Wave/Twist in Tube
Marks/Chatter

Set-up
BOM/Route
Broken/Damage/Defect
Inspection Incomplete/Unqualified
Contamination
Countersink
Cut Too Short
Instructions Incomplete/Unclear
Drill Holes

Wrong
Wrong Stock Pulled
Out of Sequence
Off-set
Mislabeled
Fit/Function
Misaligned/off center

Positioned Wrong
Outside Dimensions
Over/Under tolerance
Part Incorrect
Part Lost/Missing
Part Moved
Drawing
Finish
Misread
Turning Sequence

OTHER : _____

QC / QA Coordinator
Approval

Lead / Supervisor
Approval Verification

Completed By

AN5-36A	8	306	0
D2230-3	8	20	0
D2618	8	154	0
D2732	4	363	0
D3078-042	4	0	0
D3235-1	8	246	0
D3338-1	4	29	0
MS21042L3	8	1,923	0
MS21042L4	24	3,141	0
MS21042L5	8	661	0
NAS1149D0363J	16	2,235	0
NAS1149D0463J	48	5,339	0
NAS1149D0563J	16	2,099	0

Part Specifications

Specifications could not be found.

Plex 6/7/18 10:49 AM dart.lajeunesse.marie

PAGE 1 OF 1

Description: HELI-ACCESS STEP, HIGH SKID, SHORT STEP, LH/RH

H:\Forms\Engineer\Approved Eng Online\CHGREC revB

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Hel-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Hel-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Hel-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Hel-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Hel-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Hel-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.